

Work Order ID 66129

Monday, February 07, 2011 10:54:16 AM

Page 1

Item ID: D3566-1

Accept

Revision ID:

Item Name: Gasket

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: MF Date: 11-02-07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3566	Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3566 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

B11-2-10

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-2-10

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

M 11 02 10 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

22 BL 11-02-10.

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10
m
11-02-10

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Picklist Print

Monday, February 07, 2011 10:54:13 AM

Page 1

Work Order ID: 66129



Parent Item: D3566-1



Parent Item Name: Gasket

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	177.5000	0.911	20.24444		21.	
NEOPRENE SHEET 0.063												11-2-10	

Location

Loc Qty

Loc Code

MAT

177.5

115916

177.5

115916

22

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DART AEROSPACE LTD		Work Order: 66129
Description: Gasket		Part Number: D3566-1
Inspection Dwg: D3566	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.10	+/-0.030	3.10	X		V Bo2	
18.00	+/-0.030	18.00	A		T Bo1	
12.10	+/-0.030	12.10	B		T	
2.43	+/-0.030	2.425	A		V	
6.00	+/-0.030	6.00	A		T	
1.40	+/-0.030	1.40	B		V	
0.30	+/-0.030	.306	A		V	
0.30	+/-0.030	.304	A		V	
0.063	+/-0.010	.061	2		V	
Ø0.188	+0.005/-0.001	.190	2		V	

Measured by: EB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-2-9	Date: 11-02-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC/DD [Signature]	EB

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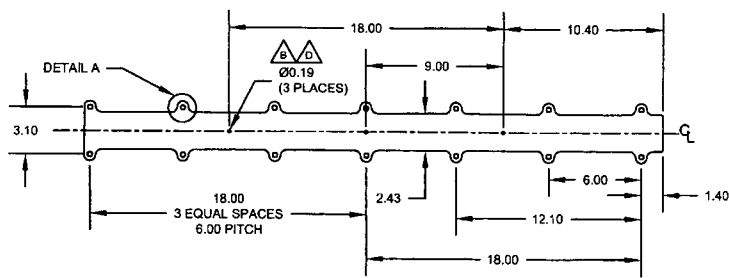
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

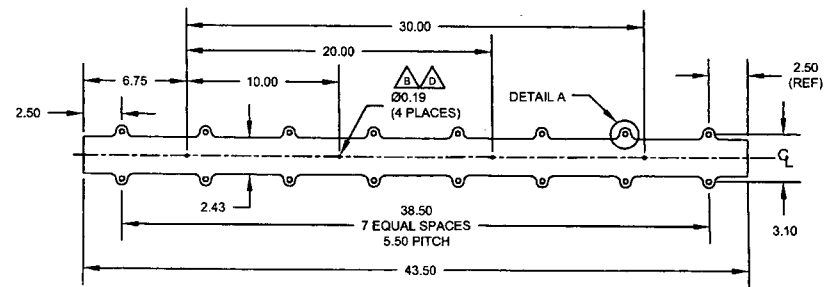
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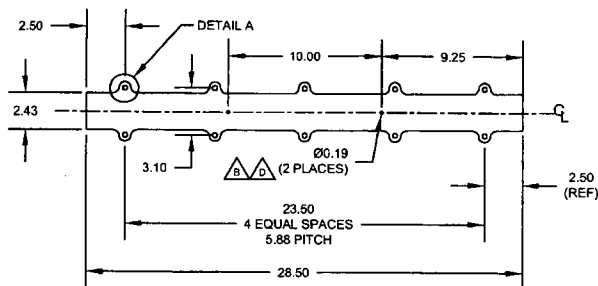
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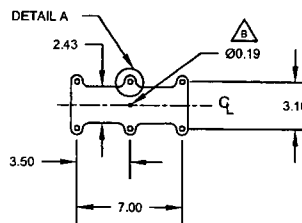
D3566-1 GASKET



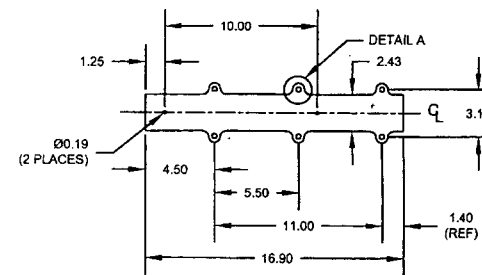
D3566-5 GASKET



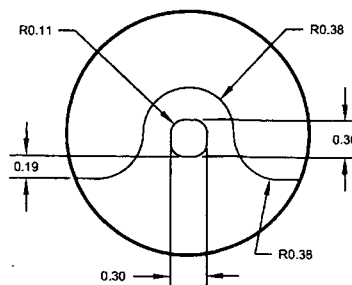
D3566-7 GASKET



D3566-13 GASKET



D3566-15 GASKET



DETAIL A
SCALE 1:1

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) PARTS ARE SYMMETRIC ABOUT \bar{C}

RELEASED

07.08.04

C	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;	CB	07.08.21
B	ADD DRAIN HOLES	PH	07.04.17
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3566	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	GASKET	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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